

# Work Order ID 95573

\*95573\*

Page 1

Monday, January 14, 2013 11:00:51 AM

Item ID: D3676-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bubble Window, LH  
 Start Date: 1/14/2013 Start Qty: 2.00 \*2\* Cust Item ID: HAL  
 Required Date: 1/31/2013 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan:   *H*   Date: 13-01-14 Tooling:            Date:            Run Start \*NR1\*  
 QC:            Date:            SPC (Y/N):            Date:            Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3676	Rev C								

100

0.00

\*100\*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up Machine as per folio FTA 018 and D3676 program

x2

DA  
07  
89  
13/1/14

110

0.00

\*110\*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to 38" by 52"

x2

DA  
07  
89  
13/1/14

**Work Order ID 95573****\*95573\***

Page 2

Monday, January 14, 2013 11:00:51 AM

Item ID: D3676-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bubble Window, LH  
Start Date: 1/14/2013 Start Qty: 2.00 **\*2\*** Cust Item ID:  
Required Date: 1/31/2013 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

**\*120\***

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

Thermoform as per Dwg. D3676 and Folio FTA 018

Dwg. Rev. CFolio Rev. D

1- Visually inspect for proper formation of each part  
2- Check depth of bubble

0.00

0.00

x2

DAS  
07  
09

13/1/14

150

**\*150\***

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

- 1) Trim off excess flange material  
2) Buff out any light scratches or blemishes  
3) Etch part number and batch number

0.00

0.00

x2

DAS  
07  
09

13/01/30

**\*95573\***

Monday, January 14, 2013 11:00:51 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**Start Date:** 1/14/2013      **Start Qty:** 2.00      **\*2\***

**Cust Item ID:**

**Required Date:** 1/31/2013      **Req'd Qty:** 2.00      **\*?\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

## Memo

0.00

### Quality Control

1) Visually inspect for clarity, and proper formation.

180

Identify as per dwg &amp; Stock Location:\_\_\_\_\_ 0.00

0.00

**\*180\***

## Packaging

## Memo

0.00

## Packaging

**Work Order ID 95573****\*95573\***

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Monday, January 14, 2013 11:00:51 AM

Item ID: D3676-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Bubble Window, LH  
Start Date: 1/14/2013      Start Qty: 2.00      **\*2\***      Cust Item ID:  
Required Date: 1/31/2013      Req'd Qty: 2.00      **\*2\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

MC 13-01-31

# Picklist Print

January-31-13 11:45:34 AM

Page 1

Work Order ID: 95573

**\*95573\***

Parent Item: D3676-1

**\*D3676-1\***

Parent Item Name: Bubble Window, LH

Start Date: 1/14/13

Required Date: 1/31/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A New Product 01/24/2008 DL Verified:JLM  
IPP Rev B Change Mat. to .236"" 08/29/2008 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased		No		110	sf	217.5260	13.75	27.51376			

**\*MACRI ICS 236\***  
Plexiglass G .236"

\*\*

DA  
07  
2-89

13/01/31

Location

Loc Qty

Loc Code

therm

217.526

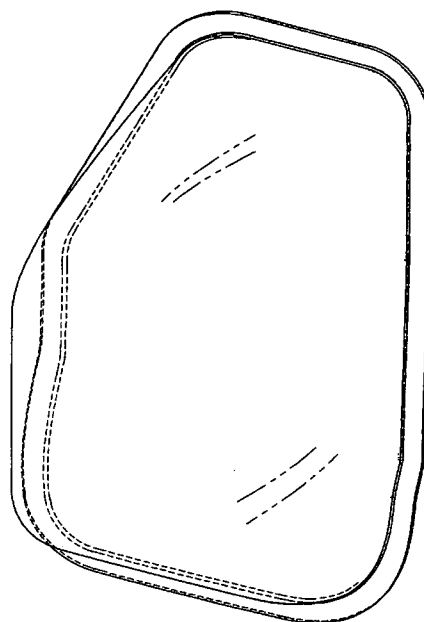
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153

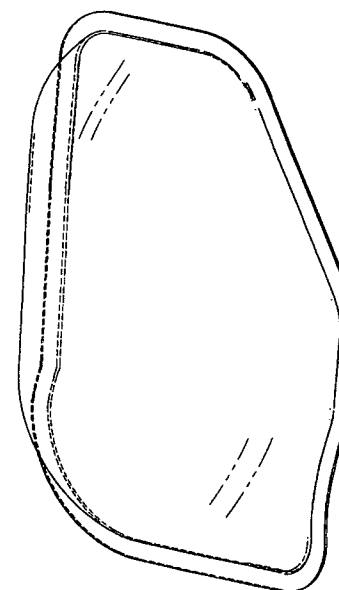
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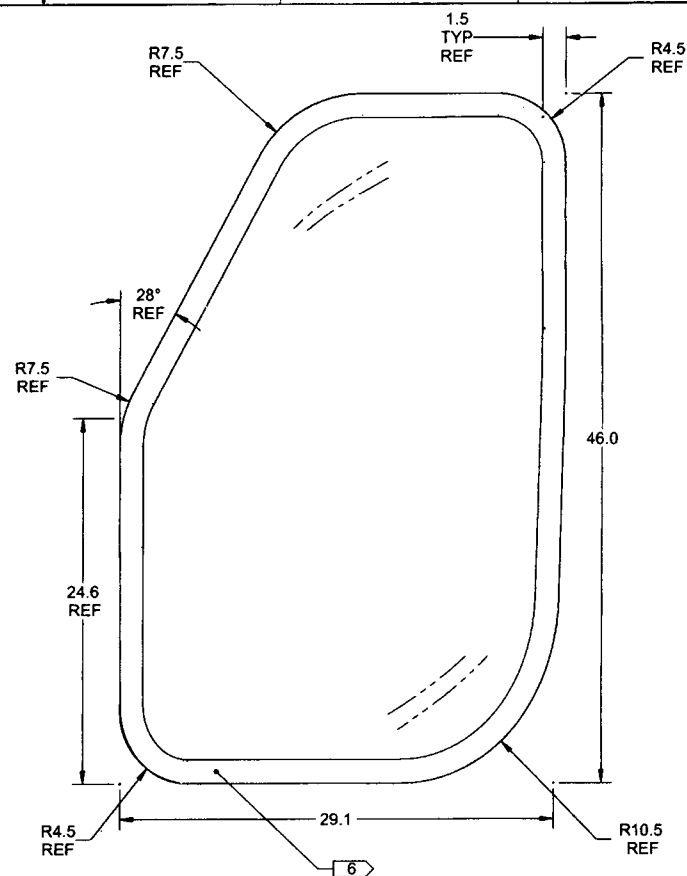
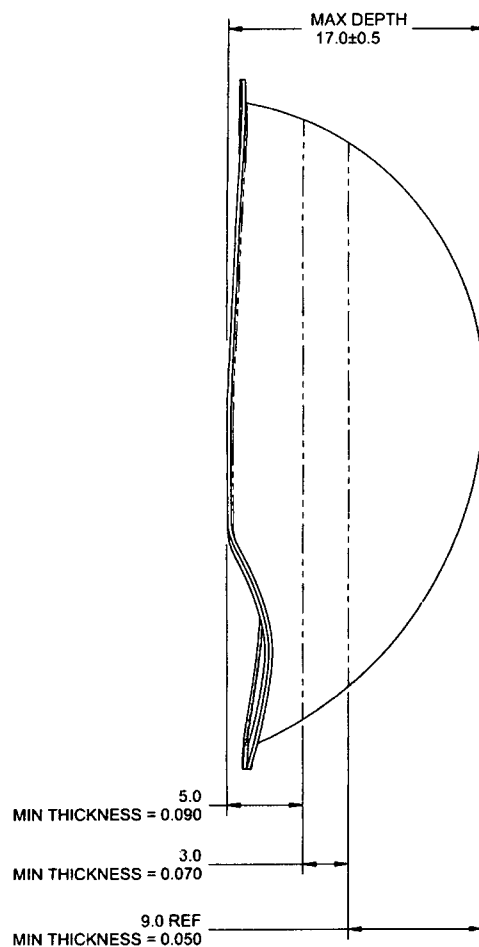
**D3676-1 FULL HEIGHT BUBBLE WINDOW (LH)**



**D3676-2 FULL HEIGHT BUBBLE WINDOW (RH)**

**RELEASED**  
2012-03-08

C	ADDED D3676-2 FULL HEIGHT BUBBLE WINDOW (RH). REMOVED NOTES ON SHEET 1, REFORMAT NOTES 6 & 8 ON SHEET 2. D3676-1 WAS "412 BUBBLE WINDOW" NOW "FULL HEIGHT BUBBLE WINDOW (LH)".	AP	12.03.01
B	REVISED TOLERANCE ON MINIMUM THICKNESSES (ZN A8/B8-2). REASON: PRODUCTION FACILITY.	MB	08.10.27
A	NEW ISSUE	MB	08.02.29
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	SEP	DRAWING NO.	REV. C
MFG. APPR.	SEP	D3676	SHEET 1 OF 3
APPROVED	SEP	TITLE	SCALE
DE APPR.	SEP	FULL HEIGHT BUBBLE WINDOW	NTS
DATE	12.03.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**D3676-1 FULL HEIGHT BUBBLE WINDOW (LH)**

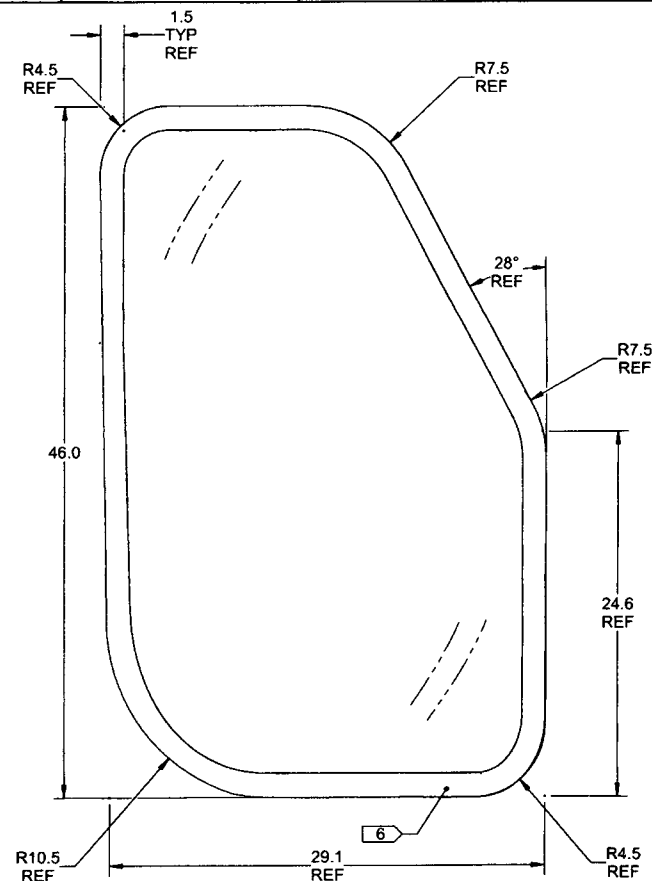
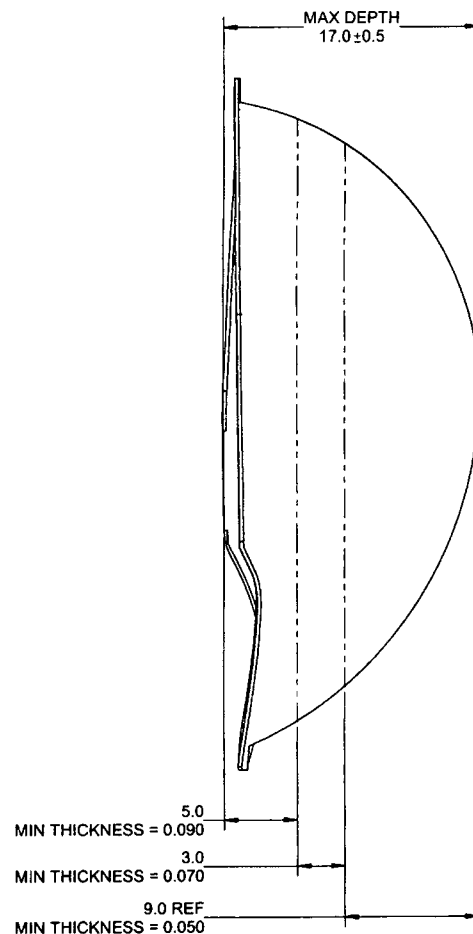
95573

**RELEASED**  
2012-03-08

**NOTES:**

- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C  
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,  
0.236 THICK ( REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D3676-1" & B/N "BXXXXX" ON FLANGE WITHIN 0.25" OF BUBBLE.  
USE 0.125" LETTERS TO MAX. DEPTH OF 0.005" PER DART QSI 044 6.4 WITH VIBRATING STYLUS.
- 7) WEIGHT: 11.0 lbs
- 8) THERMOFORM PER DART QSI 022 USING DT8992

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3676	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FULL HEIGHT BUBBLE WINDOW	NTS
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**D3676-2 FULL HEIGHT BUBBLE WINDOW (RH)**

**RELEASED**  
2012-03-03

**NOTES:**

- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C  
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,  
0.236 THICK (REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D3676-2" & B/N "BXXXXX" ON FLANGE WITHIN 0.25" OF BUBBLE  
USE 0.125" LETTERS TO MAX. DEPTH OF 0.005" PER DART QSI 044 6.4 WITH VIBRATING STYLUS.
- 7) WEIGHT: 11.0 lbs
- 8) THERMOFORM PER DART QSI 022 USING DT9794

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AP	D3676	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	FULL HEIGHT BUBBLE WINDOW	NTS
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